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(54) INJECTION MOLDING DIE

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(57) Abstract:

**PURPOSE:** To provide an injection molding die in which resin flows uniformly into a cavity, and a pressure loss is reduced and which can give a high quality molded product.

**CONSTITUTION:** A movable die 3 which can advance/back to/from a fixed die 2 is provided, and a cavity 35 is formed between the dies 2, 3. A resin injection port, a resin passage 25a which communicates with the port, and a ring-shaped gate 30 which communicates with the passage 25a and leads molten resin to the cavity 35 are installed. In addition, a sleeve guide needle 31 is installed which is bonded/supported to/by a cavity core 36 which penetrates the passage 25a and the gate 30 and forms the cavity by its end part, and a sleeve valve 33 which opens/closes the gate 30 freely advancingly/backing in the axial direction is engaged with the needle 31.

